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D3065-1
Job Sheet 178558



Part No: D3065-1

Job Qty: 40 ea

21
9-89

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		6/22/18	0.00	0.00	Start Up Waterjet		SC 8/10/11
100	Waterjet	40 pcs		6/22/18	0.00	1.41	Waterjet1		SC 8/10/11
120	QC	40 pcs		6/22/18	0.00	0.00	QC8		38
132	Brake NC	40 pcs		6/22/18	0.02	1.07	Brake NC 2		38
150	QC	40 pcs		6/22/18	0.00	0.00	QC5		38
160	HandFinish	40 pcs		6/22/18	0.00	0.58	HandFinish1		BEB 8/10/11
161	QC	40 pcs		6/22/18	0.00	0.00	QC7-1		38
180	Packaging	40 pcs		6/22/18	0.00	0.00	Packaging3-1		8/18-7-3
190	QC21-SA	40 Ea		6/22/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg D3065
Descriptions: 180 - LOCATION : GA

21
9-89 JUL 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	4.9520 sf (.1238 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	5	171	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250inches ± 0.010	0.260 0.240	0,251	
2	Step Spacer	2.093inches ± 0.010	2.103 2.083	2,095	
3	Step Spacer	3.936inches ± 0.010	3.946 3.926	3,940	
4	Step Spacer	4.186inches ± 0.010	4.196 4.176	4,190	
5	Step Spacer	0.587inches ± 0.010	0.597 0.577	0,590	
6	Step Spacer	0.128inches	0.133	0,130	



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Rework ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Completed By _____ and / Supervisor _____ Qual Verification _____ QA Coordinator Approval _____
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
NCR No. _____	Use-as-is ☐	Finishing ☐	Bar/Stars/Barboring ☐	Other ☐	
Date: _____	Step #: _____	Container No: S080040 Part: D3065 - 1 Job No: 178558 Serial No/Batch: S080040 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____			
Description Work Order Deviation: _____		Date: 06/11/18			
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/1 ☐	Grain ☐	Over/Under tolerance ☐	ioned Wrong de Dimensions Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
Design ☐	Operator ☐	Bending ☐	Weld ☐	Part Incorrect ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Out of Sequence ☐	Part Moved ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Off-set ☐	Drawing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Mislabeled ☐	Finish ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Fit/Function ☐	Misread ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Misaligned/off center ☐	Turning Sequence ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				
OTHER: _____					

		+ 0.005 - 0.001	0.127	
7	Step Spacer	0.125inches $\pm$ 0.010	0.135 0.115	0,124
8	Step Spacer	3.465inches $\pm$ 0.010	3.475 3.455	3,468
9	Step Spacer	1.250inches + 0.012 - 0.001	1.262 1.249	1,252
10	Step Spacer	0.368inches $\pm$ 0.010	0.378 0.358	0,370
11	Step Spacer	0.871inches $\pm$ 0.005	0.876 0.866	0,870
12	Step Spacer	0.040inches $\pm$ 0.010	0.050 0.030	0,040

Plex 6/1/18 1:55 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					